

Thursday, 5/10/2007 2:08:20 PM
User: Kim Johnston

Process Sheet

SP11P

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32253 -2
Estimate Number : 10851
P.O. Number : N/A
This Issue : 5/10/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LARGE FAB ASSY
Previous Run : 26752
Written By :
Checked & Approved By :
Comment : Est Rev:D As Per Ecn766 06-01-06 JLM

Drawing Name : 206L FLOAT STEP
Part Number : D206628023
Drawing Number : N/A
Project Number : N/A
Drawing Revision : N/A
Material : N/A
Due Date : 5/30/2007 Qty: 1/4 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-023 CHG 002

2.0

32253A

FLOAT STEP ASSEMBLY LH (206/407)



Comment: Sub-Component Sub-Assembly

FLOAT STEP ASSEMBLY LH (206/407)

D2842-041 B 32253A

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0

D27317

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 Mounting Lug

B29 339 ✓

5.0

D28441

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1 Arm

B29 785 ✓

7/6/258

7/6/21 59

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32253

Part Number: D206628023

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2844-3 Arm B14087 ✓

7.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2660 f(s)/Unit Total: 5.0639 f(s)

Pick:

Qty Part # Description Batch

2 D2856-400 6.9" Abrasion Strip

B32020 ✓

B32020

8.0

D3394043

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 LUG ASS,Y

B30998 ✓

B30998

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3C4A Bolt

M104214 ✓

M104214

10.0

AN4C12A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4C12A Bolt

M103691 ✓

M103691

11.0

AN4C13A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4C13A Bolt

M9600 ✓

M9600 7/6/25 SP
M94597 7/6/21 SP

ie: Thursday, 5/10/2007 2:08:20 PM
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Drawing Name: 206L FLOAT STEP

Part Number: D206628023

Job Number: 32253

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number
4 AN4C15A

Description
Bolt

Batch

2
M100447

WASHER

M102959 M102959

13.0

AN960C10



Comment: Qty.: 3.0000 EACH(s)/Unit Total: 12.0000 EACH(s)

Pick:

Qty Part Number
3 AN960C10

Description
WASHER

Batch

M101064

Washer

M101064

14.0

AN960JD416L



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number
24 AN960JD416L

Description
Washer

Batch

M103962

Inventory

M104214 M104214

15.0

NAS1515H4L



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number
24 NAS1515H4L

Description
Washer

Batch

M103691

Nut

M103691

16.0

MS210434



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick:

Qty Part Number
12 MS21043-4

Description
Nut (or MS21042-4)

Batch

M103715

Washer

M103715

17.0

NAS1515H3



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number
3 NAS1515H3

Description
Washer

Batch

M100993

M100993

7/1/21 50

re: Thursday, 5/10/2007 2:08:20 PM
ser: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L FLOAT STEP

Job Number: 32253

Part Number: D206628023

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10/6/28 (C) *SB 07/06/28* (1)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-023

Location: _____

PPP Rev: _____

E

10/6/28

(C)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/6/29 (1)

Job Completion



10/6/28

206-628.023

Dart Aerospace Ltd.

Date: Thursday, 5/10/2007 2:08:37 PM
User: Kim Johnston

Process Sheet

dy 28/06

Split 206-21

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT STEP ASSEMBLY LH (206/407)

Job Number : 32253A-1-2

Estimate Number : 11664

P.O. Number : N/A

This Issue : 5/10/2007 S.O. No. : N/A

Part Number : D2842041

Prsht Rev. : NC Drawing Number : D2842 REV B

First Issue : N/A Project Number : N/A

Previous Run : 31241A Type : LARGE FAB ASSY Drawing Revision : B

Material : N/A

Due Date : 5/30/2007 Qty: 4 Um: Each

Written By : 07.05.10

Checked & Approved By : 07.05.10

Comment : Est Rev.D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B31984

Check Material for any Dents or Defects

0.7 07.06.19

4

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

0.7

07.06.19

4

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

3-Deburr and bevel ends for welding

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B30883

07.06.19

4

4.0 D34593 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

07.06.19

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:08:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32253A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 D3459-3 Lug

331238

FF 07-06-19 4

5.0

D34591

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D3459-1 Lug

330909 =

FF 07-06-19 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT as per Dwg D2842

A/R AL Rod Batch:

m102756
m104305

2-Grind end cap weld flush

FF 07-06-20
PE 07-06-20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-06-20 (4)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-06-20 (4) (3)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-06-20

10.0


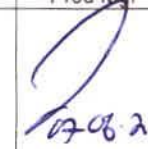

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-06-21 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070621	9.0	Split for Qty 3 on this w/o, & Qty 1 on split -1		070621	3		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:08:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32253A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M102756

2-Grind end cap weld flush.

Q.M

07.06.21

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M07/06/21 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

WJ 07.06.21 (LH)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine end cap and Powder Coat Gloss White (Ref: 4.6.5.1) as per QSI 005 4.3

07-06-25

M104144 BR/

(5)

15.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3

NAS1329C3KB130

Insert

M102974

16.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M19527

WJ 07.06.25 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:08:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 32253A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

M104603

18.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

M102473

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch:

M104733

07-06-25 (3)

20.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

P-7/6/28

(1)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PDA B32253

P-7/6/28 (1)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-06-29 (1)

Job Completion



07-06-28 1

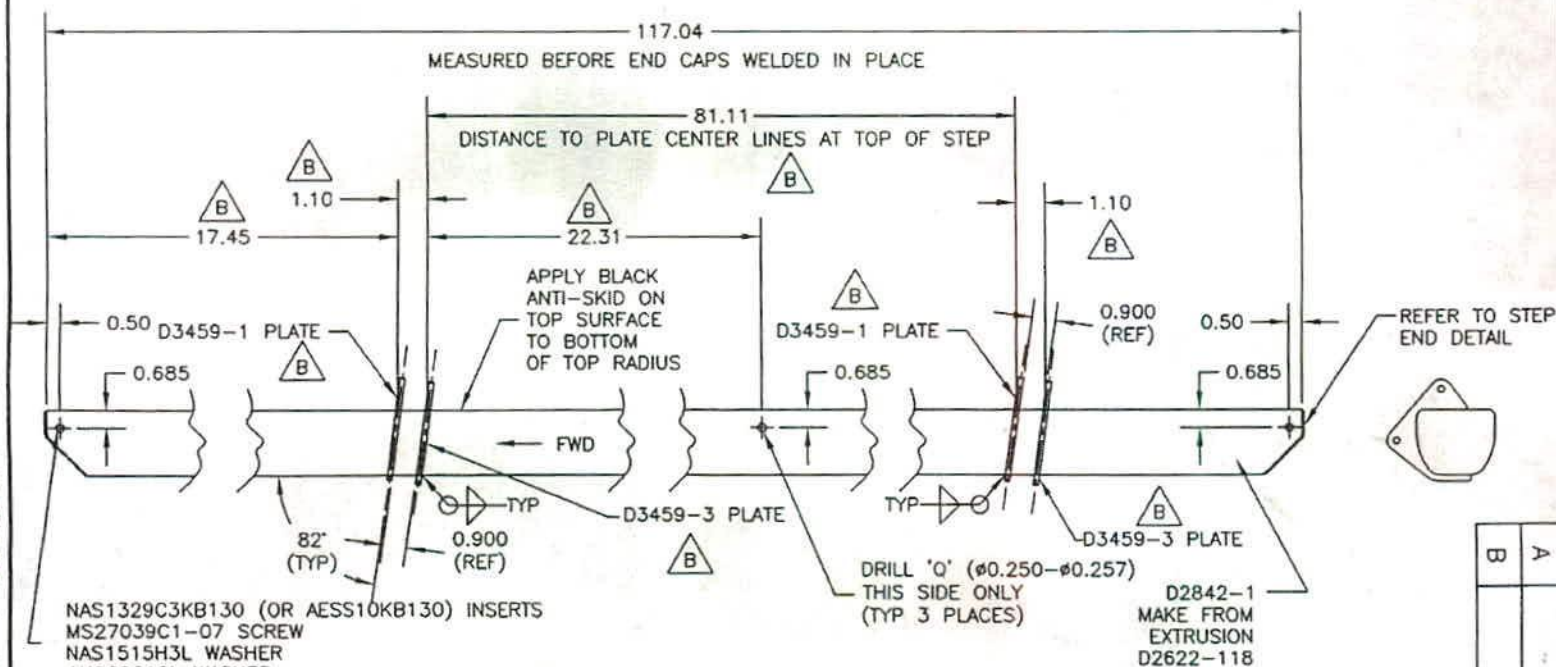
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

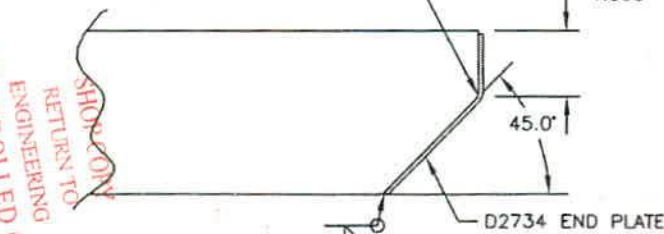
NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOW ONLY
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05.11.14

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23			TITLE
				D2842
				206L/407 FLOAT STEP ASSEMBLY
				NEW ISSUE
				RE-DESIGN, ADD D3459-1/-3
				SCALE
				SHEET 1 OF 1
				REV. B